

Work Order ID 70540

Friday, June 10, 2011 2:56:56 PM



Page 1

Item ID: D206-628-034

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH

Stop



Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-034 CHG 002

CHC 7003 8/16/24

DL 11-6-22 P/B →

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB 11/06/22

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

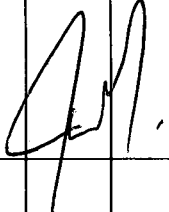
0.00

Quality Control

8/16/24

+2 RH

70543

W/O: 70540		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
u/6/24	#100	Perm. change Fix header Box AND CHG 12!					5 u/6/24	

Part No: D206-628-034 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70540

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Page 2

Item ID: D206-628-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-034

Location: _____

PPP Rev: _____

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

6/10/27

11/6/27

MF
11-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:57:03 PM

Page 1

Work Order ID: 70540

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH






Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																					
AN3C4A  BOLT		Purchased	No			110	Each	1,929.000	3	6	✓																							
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST350</td><td>1929</td><td></td></tr><tr><td>117094</td><td>427</td><td></td></tr><tr><td>117313</td><td>2</td><td></td></tr><tr><td>117688</td><td>800</td><td></td></tr><tr><td>117795</td><td>500</td><td></td></tr><tr><td>117872</td><td>200</td><td>117872</td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST350	1929		117094	427		117313	2		117688	800		117795	500		117872	200	117872
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																
ST350	1929																																	
117094	427																																	
117313	2																																	
117688	800																																	
117795	500																																	
117872	200	117872																																
AN4C14A  Bolt		Purchased	No			110	Each	54.0000	8	16	✓																							
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST337</td><td>40</td><td></td></tr><tr><td>117688</td><td>40</td><td></td></tr><tr><td>ST357</td><td>14</td><td></td></tr><tr><td>117366</td><td>14</td><td>117366 14</td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST337	40		117688	40		ST357	14		117366	14	117366 14						
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																
ST337	40																																	
117688	40																																	
ST357	14																																	
117366	14	117366 14																																
AN4C15A  Bolt		Purchased	No			110	Each	125.0000	4	8	✓																							
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST358</td><td>125</td><td></td></tr><tr><td>115835</td><td>25</td><td></td></tr><tr><td>115936</td><td>2</td><td></td></tr><tr><td>117441</td><td>48</td><td>117441</td></tr><tr><td>117795</td><td>50</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST358	125		115835	25		115936	2		117441	48	117441	117795	50				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																
ST358	125																																	
115835	25																																	
115936	2																																	
117441	48	117441																																
117795	50																																	

8-12

8-12

8-12

JB

JB

JB

[Signature]

[Signature]

117872
117688 2x
117366 14
117441
11/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:57:03 PM

Work Order ID: 70540

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C10 NAS1149C0363 Purchased No

110 Each

0.0000

3

.6

✓



114742 JB L

WASHER AN960C416L NAS1149C0432R Purchased No

110 Each

0.0000

24

48

✓



117291 JB L

WASHER D2731-3 Manufactured No

110 Each

92.0000

4

8

✓



JB L

Mounting Lug

Location

Loc Qty

Loc Code

ST469

92

47967

61

52329

31

47967

D2732 Manufactured No

110 f

233.3281

2

4

✓



JB L

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

233.32811

64283

233.32811

64283

D2842-042 Manufactured No

110 Each

0.0000

1

2

✓



70843 L

Step Assembly, RH, 206 Float

D2844-1 Manufactured No

110 Each

11.0000

2

14

✓



JB L 6/4/23

Arm

Location

Loc Qty

Loc Code

ST265

11

62954

11

62954

Friday, June 10, 2011 2:57:03 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 3

Work Order ID: 70540

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

D2844-3
Arm

Manufactured No

110 Each

16.0000

1

2

Location

Loc Qty

Loc Code

ST265

4

62967

4

ST266

12

66822

12

D3394-041
Lug Assembly

Manufactured No

110 Each

55.0000

4

8

Location

Loc Qty

Loc Code

MEZZ

15

56528

15

ST474

40

68257

40

MS21043-4
Nut

Purchased No

110 Each

1,269.000

12

24

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

171

117423

171

ST301

1058

114784

47

115936

11

117601

500

117793

500

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:57:04 PM

Page 4

Work Order ID: 70540

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased

No

110

Each

148.0000

3

6

✓



Washer

Location

Loc Qty

Loc Code

ST277

148

116373

48

117460

100

NAS1515H4L

Purchased

No

110

Each

186.0000

24

48

✓



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

146

117363

146

117460

48

117363

JB

11/06/22

Friday, June 10, 2011 2:57:04 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628

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5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

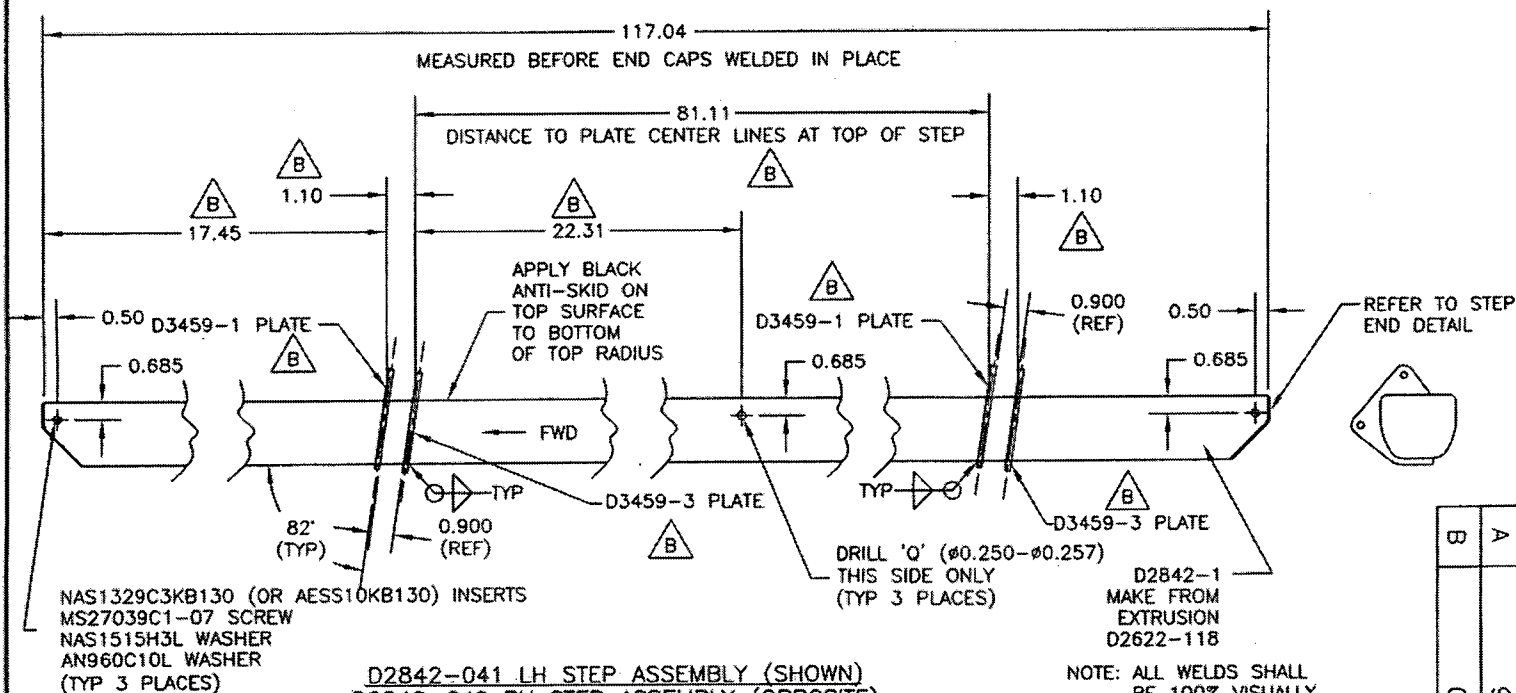
5.3 QUICK RELEASE PIP PIN KIT

Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

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Revision: G

Date: 11.02.25

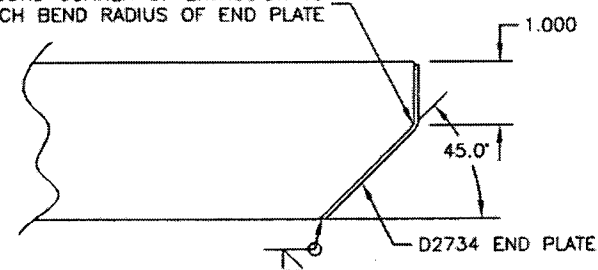


D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
5.4.14

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HARBOR, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY
		SCALE NTS
		REV. B
		SHEET 1 OF 1
		RE-DESIGN, ADD D3459-1/-3
		NEW ISSUE
		05.09.23
		98.10.13
		A
		B

REFERENCE ONLY

Change Record

Part Number D206-628-633/-034

Description HELI-ACCESS-STEP Installation (407 FLOAT)

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